

Work Order ID 83850

83850

Page 1

Thursday, April 26, 2012 1:29:12 PM

Item ID: D4093-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 4/26/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 5/4/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: P Date: 120424 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4093	C

110

0.00

110

Waterjet

FLOW CNC Waterjet

6061 .750 X 6.

Memo

CUT AS DWG

DWG REV: C

PROG REV: C

****DEBURR****

0.00

6

0

Jm

12-5-13

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.00

6

0

Jm

12-5-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 83850***83850***

Page 3

Thursday, April 26, 2012 1:29:12 PM

Item ID: D4093-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 4/26/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 5/4/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		1 1		6		12-5-12	
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00				6		12-5-12	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>195</u> Memo	0.00 0.00				6			SP D-5-22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

83850

Thursday, April 26, 2012 1:29:12 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

6

Cust Item ID:

Start Date: 4/26/2012 **Start Qty:** 6.00

Required Date: 5/4/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/2020

mt
12-05-77

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 26, 2012 1:29:16 PM

Work Order ID: 83850

83850

Parent Item: D4093-1

D4093-1

Parent Item Name: Bracket

Start Date: 4/26/2012

Required Date: 5/4/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: Ipp Rev:A New Issue 10-05-31 JLM Verified By:DD
REV:B AS PER REV C 11.09.28 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X06.00
0

Purchased

No

f

40.0000

6

M6061T6B0 750X06 000

**

6061T6 BAR .750 X 6.00

Location

Loc Qty

Loc Code

MAT004

40

121380

40

121380

JM 11
12-5-13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	- 83850
Description: Bracket		Part Number:	D4093-1
Inspection Dwg: D4093	Rev: C	Page 1 of 1	

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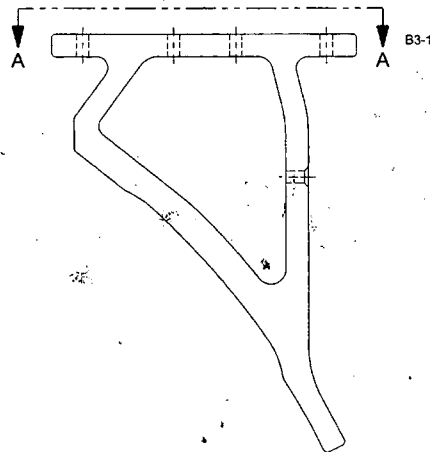
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

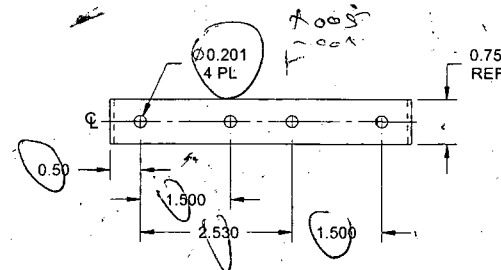
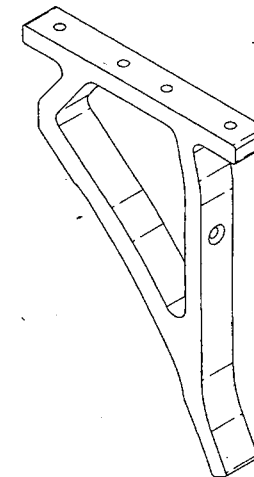
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83850
PL-04-24



SECTION VIEW A-A D6-1

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.54 lbs

D4093-1 BRACKET

1.000 ± .010
1.00 ± .030
1.0 ± .00

RELEASED
2011-09-22

C	REDRAWN D4093-1/3 (ZN B4-1, B4-2); ADD MATERIAL NOTES (ZN A8-1, A8-3, A8-5)	RF	11.07.27
B	REDRAWN D4093-1/3 (ZN B4-1, B4-2)	RF	11.01.31
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	<i>MP</i>		
MFG. APPR.	<i>MP</i>		
APPROVED	<i>MP</i>		
DE APPR.	<i>MP</i>		
DATE	11.07.27		

DART AEROSPACE USA, INC.		REV. C
DRAWING NO.	D4093	SHEET 1 OF 5
TITLE	BRACKET	SCALE
		NTS

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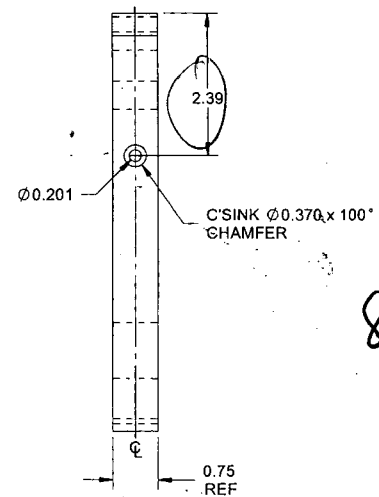
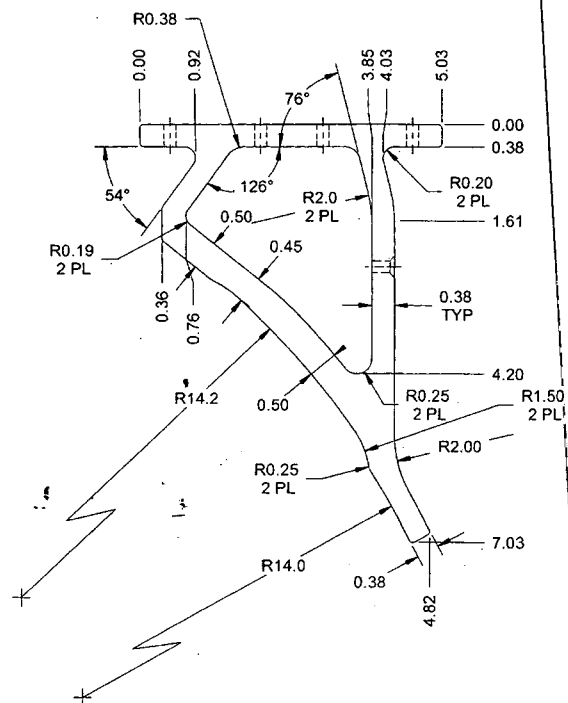
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



83850

D4093-1 BRACKET

RELEASED
2011-09-22
WJD

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>WJD</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>WJD</i>	D4093	SHEET 2 OF 5
APPROVED	<i>WJD</i>	TITLE	SCALE
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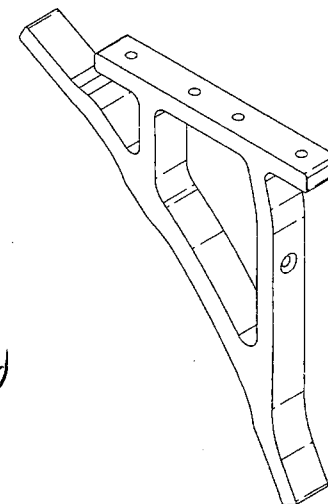
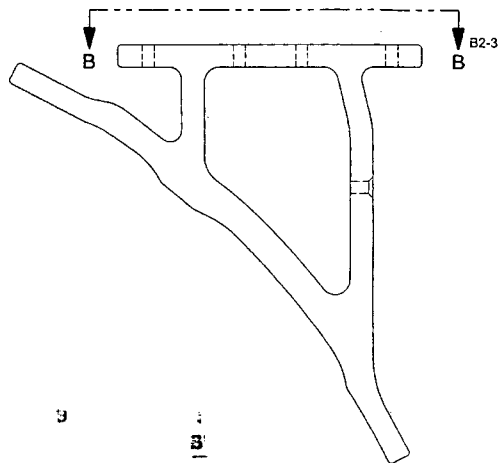
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

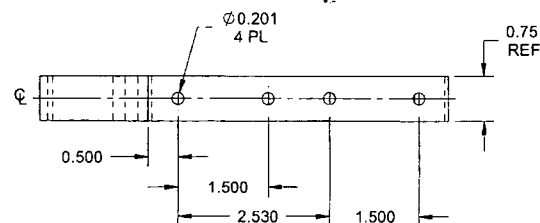
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



83850



SECTION VIEW B-B B5-3

D4093-3 BRACKET

RELEASED
2011-09-22

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4093	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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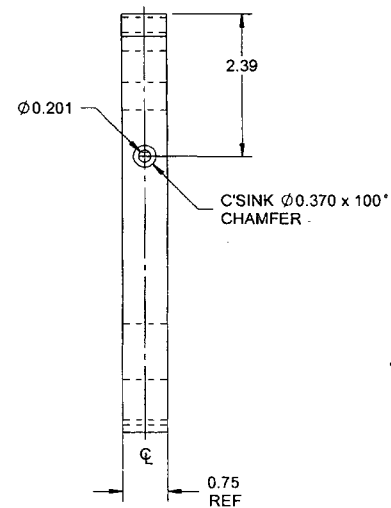
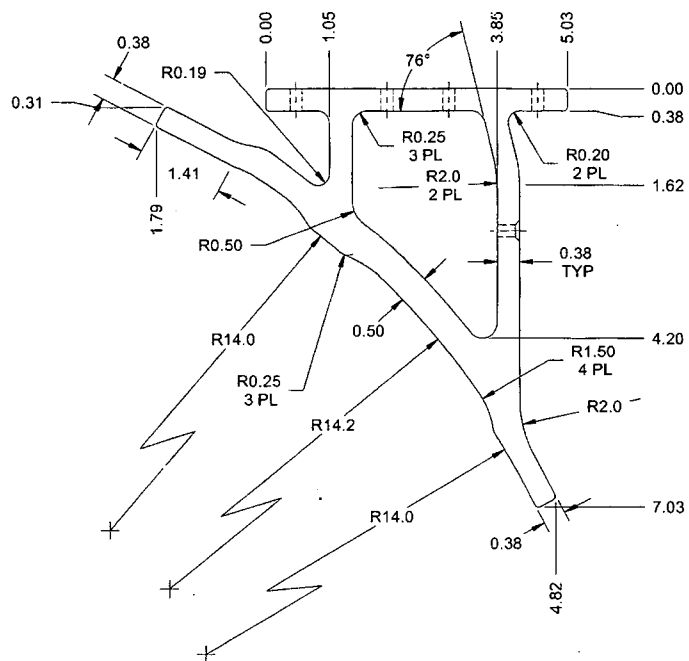
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D4093-3 BRACKET 

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2011-09-22

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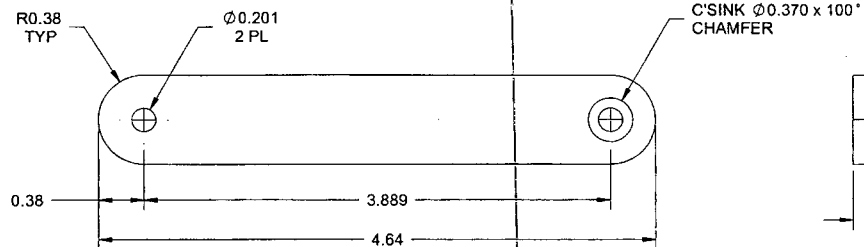
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4093-5 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6B/M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED
2011-09-22
AW

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	MP	DRAWING NO.	REV. C
MFG. APPR.	MP	D4093	SHEET 5 OF 5
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